

Work Order ID 85101

Friday, July 06, 2012 1:37:23 PM

85101**DUPLICATE** Page 1

Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

could not
find original
w/oApprovals: Process Plan: *mk*Date: *12-07-06*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-09

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001** ensure
no burn thru after welding in tube -235 and -229 only where bushing -265 ****1 0 12-07-09*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 0 BE 12-07-09

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

5/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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N900040100

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Revision ID:

Stop ***NS2***

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Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

18144 0.00

in detail D, mask in between -311 prior to paint**mask 1.750" on the end of -243 prior to paint*****mask inside of D3440-9 prior to paint***START TIME: 9:00 OVEN TEMPERATURE:

FINISH TIME: 9:30

1 131279

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

1 110704

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Packaging

Memo

0.00

Dart Aerospace Ltd

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Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

OK 12/7/10

mt
12-07-09

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Work Order ID: 85101

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
dwg EC verified by:DD

IPP RevB 10.09.24 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-201 Square Tube	N/A	Manufactured	No			100	Each	2.0000	2	2		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437		2							
				62104		2			x 2				
PB67-43001-203 Square Tube		Manufactured	No			100	Each	5.0000	1	1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437		5							
				62105		5			x 1				
* PB67-43001-209 Square Tube		Manufactured	No			100	Each	0.0000	1	1		12.07.09	
									52485				
PB67-43001-211 Square Tube		Manufactured	No			100	Each	2.0000	6	6		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				85179		2			x 2				
PB67-43001-213 Flanged Hook		Manufactured	No			100	Each	3.0000	2	2		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		3							
				52488		3			x 2				
PB67-43001-223 Square Cap	N/A	Manufactured	No			100	Each	43.0000		1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		43							
				47504		43							

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Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-225
Bushing

N/A

Manufactured No

100 Each 29.0000

4

Location

Loc Qty

Loc Code

Mezz

29

44988

29

PB67-43001-227
Bushing

N/A

Manufactured No

100 Each 33.0000

2

Location

Loc Qty

Loc Code

ST438

33

43712

2

44987

31

PB67-43001-229
Outer Tube

Manufactured No

100 Each 2.0000

1 1

Location

Loc Qty

Loc Code

ST209a

2

52487

2

1 x 54670



PB67-43001-233
Outer Tube End Cap

N/A

Manufactured No

100 Each 5.0000

1

Location

Loc Qty

Loc Code

Mezz

5

41573

5

PB67-43001-235
Outer Tube

Manufactured No

100 Each 9.0000

1 1

Location

Loc Qty

Loc Code

ST209a

9

62109

9

PB67-43001-239
Square Tube

Manufactured No

100 Each 2.0000

1 1

Location

Loc Qty

Loc Code

ST443

2

44986

2

x 1

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Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-243
Tube Handle Extension

Manufactured

No

100 Each 1.0000 1 1

12.07.09

Location

Loc Qty

Loc Code

ST438

1

3332

1

X 1

PB67-43001-277
Contoured Male Eye

Manufactured

No

100 Each 4.0000 1 1

12.07.09

Location

Loc Qty

Loc Code

ST438

4

2110

4

X 1

PB67-43001-311
Restraint

Manufactured

No

100 Each 4.0000 2 2

12.07.09

Location

Loc Qty

Loc Code

ST439

4

62112

4

X 2

* D3440-9
Tube Detent Clip Base (Supersedes B67-43001-241)

Manufactured

No

100 Each 4.0000 1 1

12.07.09

Location

Loc Qty

Loc Code

WA

4

85178

4

* D3440-13
Bracket (Supersedes B67-43001-273)

Manufactured

No

100 Each 2.0000 1 1

12.07.09

Location

Loc Qty

Loc Code

ST439A

2

41452

2

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LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
PB67-43001-235	85101	-1	62109	6/19/2012 12:50:51 PM
PB67-43001-203	85101	-1	62105	6/19/2012 12:50:51 PM
PB67-43001-311	85101	-2	62112	6/19/2012 12:50:51 PM
PB67-43001-201	85101	-2	62104	6/19/2012 12:50:51 PM
PB67-43001-211	85101	-2	85179	6/19/2012 12:50:51 PM
PB67-43001-227	85101	-2	43712	6/19/2012 12:50:51 PM
PB67-43001-239	85101	-1	44986	6/19/2012 12:50:51 PM
PB67-43001-243	85101	-1	43332	6/19/2012 12:50:51 PM
PB67-43001-277	85101	-1	62110	6/19/2012 12:50:51 PM
PB67-43001-211	85101	-4	62106	6/19/2012 12:50:51 PM
PB67-43001-213	85101	-2	52488	6/19/2012 12:50:51 PM
PB67-43001-209	85101	-1	52485	6/19/2012 12:50:51 PM
PB67-43001-229	85101	-1	54670	6/19/2012 12:50:51 PM

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